



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 178936



Part No: D350-591-311

Job Qty: 3 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/11/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Non-Airbus

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	7/6/18	7/6/18	0.00	0.00	Start Up Large Fab-4		<i>SK4</i>
110	Large Fab	3 pcs	7/6/18	7/6/18	0.00	2.97	Large Fab 2		<i>CPC</i>
120	QC	3 pcs	7/6/18	7/6/18	0.00	0.00	QC9		<i>SK4</i>
130	QC	3 pcs	7/6/18	7/6/18	0.00	0.00	QC5		<i>SK4</i>
140	HandFinish	3 pcs	7/6/18	7/6/18	0.00	0.55	HandFinish1		<i>SA 18-07-24</i>
150	QC	3 pcs	7/6/18	7/6/18	0.00	0.00	QC7-2		<i>CPC</i>
180	Large Fab	3 pcs	7/6/18	7/6/18	0.00	2.97	Large Fab 2		<i>CPC</i>
190	QC	3 pcs	7/6/18	7/6/18	0.00	0.00	QC10		<i>SK4</i>
200	QC	3 pcs	7/6/18	7/6/18	0.00	0.00	QC5		<i>SK4</i>
210	HandFinish	3 pcs	7/6/18	7/6/18	0.00	0.55	HandFinish1		<i>SA 18-07-30</i>
220	Powdercoat	3 pcs	7/6/18	7/6/18	0.00	0.87	Powdercoat1		<i>W 18-7-31</i>
230	HandFinish	3 pcs	7/6/18	7/6/18	0.00	0.55	HandFinish3		<i>KEB 18-07-31</i>
240	QC	3 pcs	7/6/18	7/6/18	0.00	0.00	QC3		<i>W 18-08-01</i>
250	Packaging	3 pcs	7/6/18	7/6/18	0.00	0.00	Packaging1-3		<i>AUG 24 2018</i>
260	QC	3 pcs	7/6/18	7/6/18	0.00	0.00	QC4		<i>6:55</i>
270	Packaging	3 pcs	7/6/18	7/6/18	0.00	0.00	Packaging3-1		<i>6:55</i>
275	DC	3 pcs	7/6/18	7/6/18	0.00	0.00	DC		<i>2:00</i>
280	QC21-FG	3 Ea	7/6/18	7/6/18	0.00	0.00	QC21		<i>21</i>

Fyofu

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod *M134785* 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod *M134785* 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: *7:30am* OVEN TEMPERATURE: *3200m* FINISH TIME: *8:00 ~*

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

wing walk. M138851

004662

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	6 Ea (2 ea)	90-Start up Operation	<i>5069554</i>
D3219-1	Plate	6 Ea (2 ea)	90-Start up Operation	<i>5083126</i>
D3272-1	Step	3 Ea (1 ea)	90-Start up Operation	<i>5091615</i>
D3065-041	Step Leg Assembly	3 Ea (1 ea)	180-Large Fab	

D3066-1	Spacer	6 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	48 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	6 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	24 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	6 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	12 Ea (4 ea)	250-Packaging
D2618	Bushing	6 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	6 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	6 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	3 Ea (1 ea)	250-Packaging
MS21042L3	Nut	6 Ea (2 ea)	250-Packaging
MS21042L4	Nut	24 Ea (8 ea)	250-Packaging
MS21042L5	Nut	6 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	12 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	48 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	12 Ea (4 ea)	250-Packaging

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	6	256	0
	D3219-1	6	155	0
	D3272-1	3	10	0
180-Large Fab	D3065-041	3	10	0
	D3066-1	6	229	0
250-Packaging	MS20600-AD4W4	48	3,996	0
	AN3-35A	6	308	0
	AN4-13A	24	1,193	0
	AN5-36A	6	302	0
	D2230-3	12	20	0
	D2618	6	148	0
	D2856-400-720	6	156	0
	D3235-1	6	246	0
	D3278-041	3	46	0
	MS21042L3	6	1,881	0
	MS21042L4	24	2,959	0
	MS21042L5	6	651	0
	NAS1149D0363J	12	2,225	0
	NAS1149D0463J	48	5,122	0
	NAS1149D0563J	12	2,091	0

D3066-1 (1 each)

Part Specifications

Specifications could not be found.

Plex 6/11/18 10:39 AM Dart.lajeunesse.marie



Container No: S091882



Part: D350-591-311

Job No: 178936

Serial No/Batch: S091882

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/16/18

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Email: sales@dartaero.com
www.dartaerospace.com



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Ship Via:

Van - Airbus

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		7/6/18	0.00	0.00	Start Up Large Fab-4		
110	Large Fab	3 pcs		7/6/18	0.00	2.97	Large Fab 2		<i>CPC</i>
120	QC	3 pcs		7/6/18	0.00	0.00	QC9		<i>SA</i>
130	QC	3 pcs		7/6/18	0.00	0.00	QC5		<i>SA 15-01-24</i>
140	HandFinish	3 pcs		7/6/18	0.00	0.55	HandFinish1		<i>CPC</i>
150	QC	3 pcs		7/6/18	0.00	0.00	QC7-2		<i>CPC</i>
180	Large Fab	3 pcs		7/6/18	0.00	2.97	Large Fab 2		<i>CPC</i>
190	QC	3 pcs		7/6/18	0.00	0.00	QC10		<i>SA</i>
200	QC	3 pcs		7/6/18	0.00	0.00	QC5		<i>SA</i>
210	HandFinish	3 pcs		7/6/18	0.00	0.55	HandFinish1		<i>SA 15-07-30</i>
220	Powdercoat	3 pcs		7/6/18	0.00	0.87	Powdercoat1		<i>SA 15-07-30</i>
230	HandFinish	3 pcs		7/6/18	0.00	0.55	HandFinish3		<i>SA 15-07-30</i>
240	QC	3 pcs		7/6/18	0.00	0.00	QC3		
250	Packaging	3 pcs		7/6/18	0.00	0.00	Packaging1-3		<i>SA</i>
260	QC	3 pcs		7/6/18	0.00	0.00	QC4		
270	Packaging	3 pcs		7/6/18	0.00	0.00	Packaging3-1		
275	DC	3 pcs		7/6/18	0.00	0.00	DC		
280	QC21-FG	3 Ea		7/6/18	0.00	0.00	QC21		

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180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 7:30 AM OVEN TEMPERATURE: 210°C FINISH TIME: 8:00 AM

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

going work. 1138851

104662

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	6 Ea (2 ea)	90-Start up Operation	
D3219-1	Plate	6 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	3 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	3 Ea (1 ea)	180-Large Fab	

D3066-1	Spacer	6 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	48 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	6 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	24 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	6 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	12 Ea (4 ea)	250-Packaging
D2618	Bushing	6 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	6 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	6 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	3 Ea (1 ea)	250-Packaging
MS21042L3	Nut	6 Ea (2 ea)	250-Packaging
MS21042L4	Nut	24 Ea (8 ea)	250-Packaging
MS21042L5	Nut	6 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	12 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	48 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	12 Ea (4 ea)	250-Packaging

DSI 9410-011

2 (ea)

8089307.
8089302
8071345
8082275
8092007
8084615
8082091
8089840
8089365
8058178
8068661
8089299
8093773
8088446

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	6	256	0
	D3219-1	6	155	0
	D3272-1	3	10	0
180-Large Fab	D3065-041	3	10	0
	D3066-1	6	229	0
	MS20600-AD4W4	48	3,996	0
250-Packaging	AN3-35A	6	308	0
	AN4-13A	24	1,193	0
	AN5-36A	6	302	0
	D2230-3	12	20	0
	D2618	6	148	0
	D2856-400-720	6	156	0
	D3235-1	6	246	0
	D3278-041	3	46	0
	MS21042L3	6	1,881	0
	MS21042L4	24	2,959	0
	MS21042L5	6	651	0
	NAS1149D0363J	12	2,225	0
	NAS1149D0463J	48	5,122	0
	NAS1149D0563J	12	2,091	0

DSI 9410-011

Part Specifications

Specifications could not be found.

Plex 6/11/18 10:39 AM Dart.lajeunesse.marie



Container No: S091882



Part: D350-591-311

Job No: 178936

Serial No/Batch: S091882

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Exp Date:

Instructions

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Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/16/18

8/1/2018

Container View (Active) - Master Unit Containers



Dart Aerospace Ltd.
1270 Aberdeen St
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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004807	S098391	AN3-35A	Bolt	S089307	ST348	6
004807	S098390	AN4-13A	Bolt	S089302	OVER003	24
004807	S098389	AN5-36A	Bolt	S071345	ST336	6
004807	S098388	D2618	Bushing	S082275	ST008	6
004807	S098387	D2856-400-720	Abrasion Strip 4" X 7.20"	S092667	ST418	6
004807	S098386	D3235-1	Mounting Lug	S089615	ST522	6
004807	S098385	D3278-041	Support Assembly	S092091	ST522	3
004807	S098384	DSI 9410-011	Amends Installation Of D350-591-311/-312 Steps	S088446	FG123	3
004807	S098383	MS21042L3	Nut	S089340	ST303	6
004807	S098382	MS21042L4	Nut	S089365	ST303	24
004807	S098381	MS21042L5	Nut	S058178	ST303	6
004807	S098380	NAS1149D0363J	Washer	S068661	ST263	12
004807	S098379	NAS1149D0463J	Washer	S089299	ST263	48
004807	S098378	NAS1149D0563J	Washer	S093773	ST263	12

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 8/1/18 2:11 PM Dart.joly.jocelyne

D2230-1 Qty 12 S103723

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY